	r ID 69054	•								Page 1
Revision ID:	D3255-2 Panel		Accept				i i s	Setup Sta	· · · · · · · · · · · · · · · · · · ·	
Start Date: Required Date: Reference:	4/27/2011 Start Qty: 6 5/3/2011 Req'd Qty: 6			Cust Item I Customer:	D:					
Approvals:	Process Plan:QC:	Date:	Tooling: SPC (Y/N):		nte:		ŀ	Run Sta Sto		
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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D3255	Rev B			• •			•			
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QC Quality Control	QC2- Inspect par	is off machine FAI/FAIB	0.00				Bil	×-4	· ·	
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Quality Control

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Memo

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Dart Aerospace Ltd

W/O:				WC	ORK ORDER CHANG	iES			•		
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Revision ID: Item Name:	D3255-2 Panel 4/27/2011 5/3/2011	Start Qty: 6.00 Req'd Qty: 6.00		Accept	Cust Item I	II		s s	etup Star Sto	1 100111111		
Approvals:	Process Pla	n:	Date:	Tooling: SPC (Y/N):		ate:		R	un Star Sto			
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140 · · · · · · · · · · · · · · · · · · ·		QC5- Inspect part comple	teness to step on W/O	00.00 S worl	د د			(+6)			,	

150

Quality Control

Packaging

Packaging

Identify as per dwg & Stock Location: W/

Memo

Memo

0.00

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Dart Aerospace	Ltd
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W/O:	•			WORK ORDER C	HANGES				
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DATE	STEP	Section A	Initia Chief Eng	Action Description Chief Eng		gn & Date	Section C	Chief Eng	QC Inspector

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Work Order ID 69054



Page 3

Wednesday, April 27, 2011 11:28:38 AM

Item ID:

D3255-2

Revision ID:

Item Name: Panel

Start Date:

4/27/2011

QC:

Required Date: 5/3/2011

Start Otv: 6.00 Req'd Qty: 6.00



Accept

Setup Start

Stop



Cust Item ID:

Customer:

Reference:

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A	nnrovale	

Process Plan:

Operation

Description

Date:

OC21- Final Inspection - Work Order Release

Date:

Tooling:

Set Up/

Run Hours

SPC (Y/N):

Date:

Run

Start

Stop



Sequence ID/

Work Center ID

160

Memo

0.00

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Tool ID

Date:

Tool # Plan Code Qty

Reject Accept Qty

Reject Number Insp. Stamp

Quality Control

Dart Aerospace	Ltd
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W/O:				WORK ORDER CHANG	ES				
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Picklist Print

Wednesday, April 27, 2011 11:28:45 AM

Work Order ID: 69054

Parent Item:

D3255-2

Parent Item Name: Panel



Start Date: 4/27/2011

Required Date: 5/3/2011

Page 1

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP Rev:A

New Issue 06-08-01 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S22GA		Purchased	No		100	sf	105.0000		9.372632			
									Æ	11-5-4		

304/316 .032 Sheet

Location	Loc Oty	Loc Code	
020	13		
109023	6		
109057	7		
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117379	92		117374

Dart Aerospace Ltd	td	_td	L	e:	C	а	Ø	S	0	er	١(1	rt	a	U
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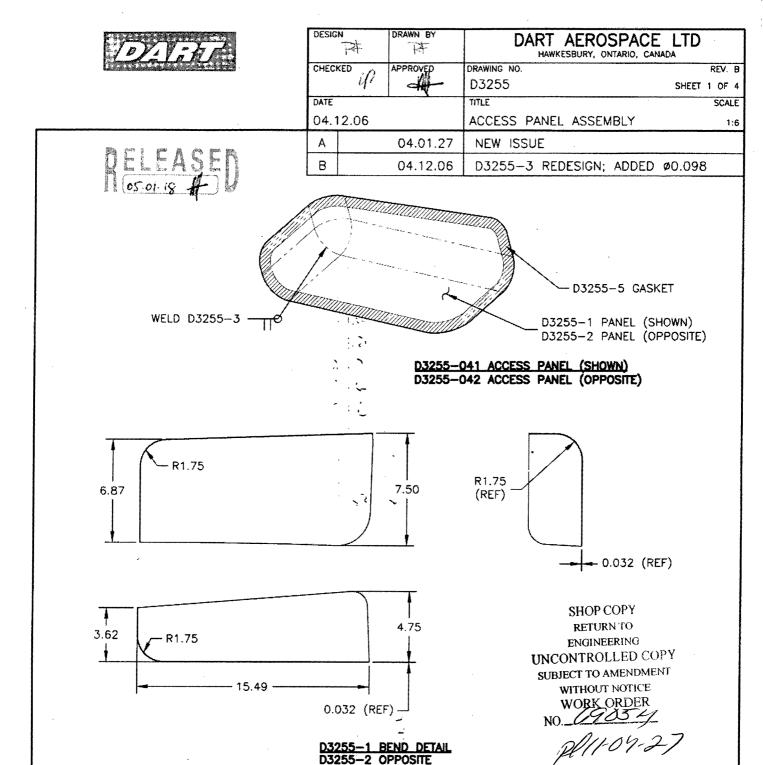
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Description: Access Panel Assembly	Part Number:	D3255-2
Inspection Dwg: D3255 Rev: B		Page 1 of 1

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11.432	+/-0.010	11.432	8		1		
2.261	+/-0.010	2.262	4		V		
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	ew Issue					KJ/DD	1

	Dart	Aero	space	Ltd
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D3255-041/-042 NOTES:

WELD PER DART QSI 004

FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3 INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS

4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

Dart	Aeros	pace	Ltd
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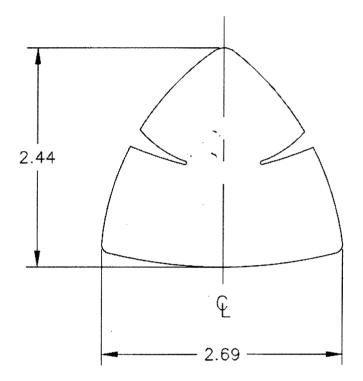
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04.12.06		TITLE	1:1





w/069054

D3255-3 CAP FORM TO FIT D3155-1/-2

D3255-3 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

Dart Aerospace	

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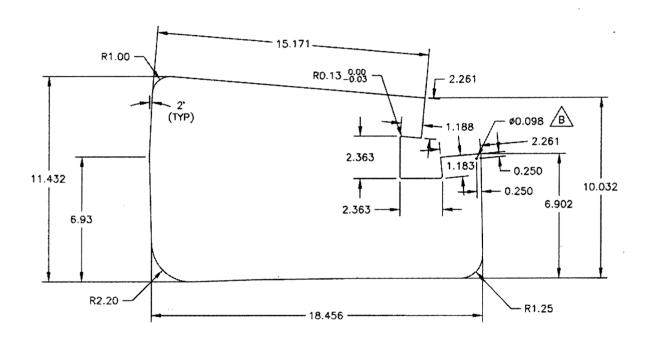
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w/0 69057



D3255-1/-2 FLAT PATTERN

D3255-1/-2 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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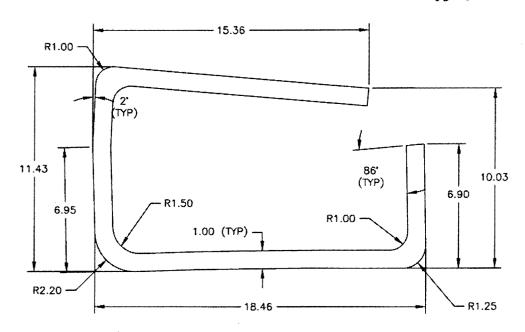
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D3255-5 GASKET

D3255-5 NOTES:

- 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F P/N SIL/F 36x36x1/16

 POSSIBLE SUPPLER: AVIALL

 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

 3) ALL DIMENSIONS ARE IN INCHES

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